

Date: Friday, 22/08/2008 2:02:27 PM
 *User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE, OUTBOARD, LH, 206
Job Number :	41596		
Estimate Number :	10818		
P.O. Number :		Part Number :	D26651
This Issue :	22/08/2008	S.O. No. :	*
Prsht Rev. :	NC	Drawing Number :	D2665 REV.D
First Issue :	/ /	Project Number :	N/A
Previous Run :	38749	Drawing Revision :	D
	Type :	Material :	
	MACHINED PARTS	Due Date :	18/09/2008
Written By :		Qty:	6
Checked & Approved By :	<u>JUL 08.8.22</u>	Um:	Each
Comment :	Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC Est Rev:D As per Rev D 07-03-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6101003	Saddle Billet, 7075
-----	----------	---------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

7075-T7351 2X6.25X7.875

Cut Size 2.0" x 6.25" x 7.88"

Grain Along Long 7.88 Length

Batch no B33792 ml 08/09/04

⑥

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Program batch number.

1- Inspect part number and batch number are programmed correctly.

2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet

3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

4- Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet

5- Deburr

ml 08/09/05

⑥

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

ml 08/09/05

⑥

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 08/09/05

⑥

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/08/2008 2:02:27 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, LH, 206

Job Number: 41596

Part Number: D26651

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SS 08/09/06

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SS 08-09-09

(X6)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M108523

START TIME:

1:15pm

OVEN TEMPERATURE:

320°C

FINISH TIME:

1:45pm

SS 08-09-10

(X6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

F2

08/09/10

(6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 436

8/9/11

(6)

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/11

Job Completion



U 08-09-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 41590
Description: 206 Saddle, Outboard, Left side	Part Number: D2665-1
Inspection Dwg: D2665 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.122	.122	.121	.122		
B	0.100	0.140		.121	.122	.120	.122		
C	1.125	1.145		1.136	1.134	1.134	1.134		
D	0.615	0.685		.658	.665	.666	.665		
E	0.240	0.260		.253	.257	.252	.252		
F	1.313	1.343		1.327	1.324	1.324	1.324		
G	0.210	0.230		.222	.221	.221	.221		
H	0.100	0.180		.146	.140	.140	.140		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.579	1.572	1.572	1.572		
K	0.235	0.240		.237	.238	.238	.238		
L	0.100	0.120		.116	.110	.116	.110		
M	0.990	1.010		1.002	1.002	1.002	1.002		
N	0.510	0.515		.576	.571	.570	.571		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.256	1.250	1.256	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.315	0.322		.320	.320	.320	.320		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.361	1.362	1.361		
V	0.787	0.807		.796	.794	.797	.796		
W	0.540	0.560		.548	.548	.546	.547		
X	1.674	1.684		1.676	1.679	1.679	1.678		
Y	0.257	0.262		.259	.259	.259	.259		
Z	0.912	0.932		.921	.922	.922	.923		
AA	0.490	0.510		.501	.503	.502	.503		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>mf</i>
Date:	08/09/05

Audited by:	<i>SB</i>
Date:	08/09/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order: 41596
Description: 206 Saddle, Outboard, Left side	Part Number: D2665-1
Inspection Dwg: D2665 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

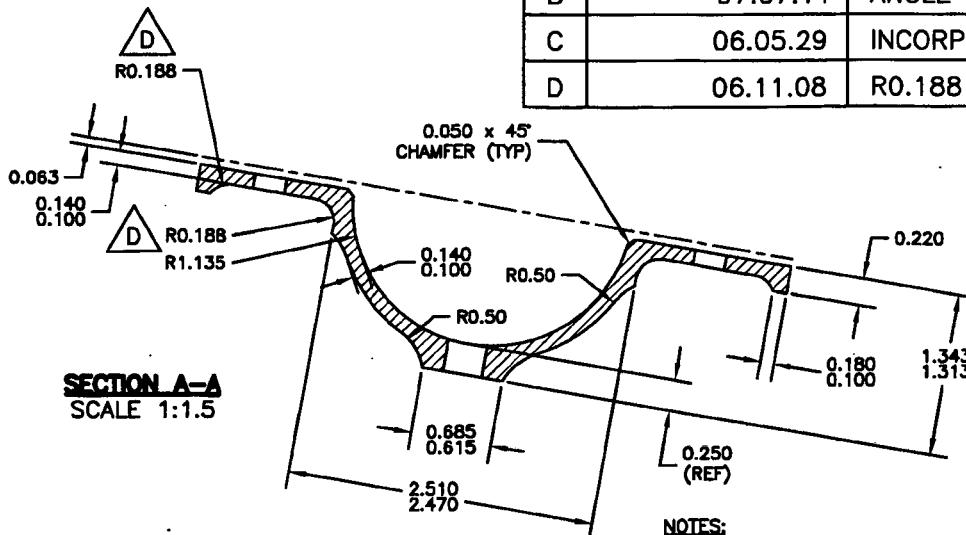
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.122	.122				
B	0.100	0.140		.121	.122				
C	1.125	1.145		1.134	1.134				
D	0.615	0.685		.665	.661				
E	0.240	0.260		.253	.253				
F	1.313	1.343		1.324	1.324				
G	0.210	0.230		.223	.222				
H	0.100	0.180		.146	.140				
I	2.470	2.510		2.490	2.490				
J	1.565	1.585		1.572	1.572				
K	0.235	0.240		.238	.238				
L	0.100	0.120		.110	.110				
M	0.990	1.010		1.004	1.005				
N	0.510	0.515		.516	.510				
O	5.990	6.010		6.000	6.000				
P	1.245	1.255		1.250	1.250				
Q	2.495	2.505		2.506	2.500				
R	0.313	0.318		.314	.314				
S	0.315	0.322		.320	.320				
T	2.495	2.505		2.506	2.500				
U	1.357	1.367		1.361	1.361				
V	0.787	0.807		.795	.795				
W	0.540	0.560		.547	.542				
X	1.674	1.684		1.678	1.679				
Y	0.257	0.262		.259	.259				
Z	0.912	0.932		.924	.926				
AA	0.490	0.510		.505	.505				
AB	0.178	0.198		.188	.188				
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>mt</i>	Audited by: <i>SP</i>
Date: 08/09/05	Date: 08/09/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	<i>[Signature]</i>

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2665	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE FWD OUTSIDE HIGH	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$	

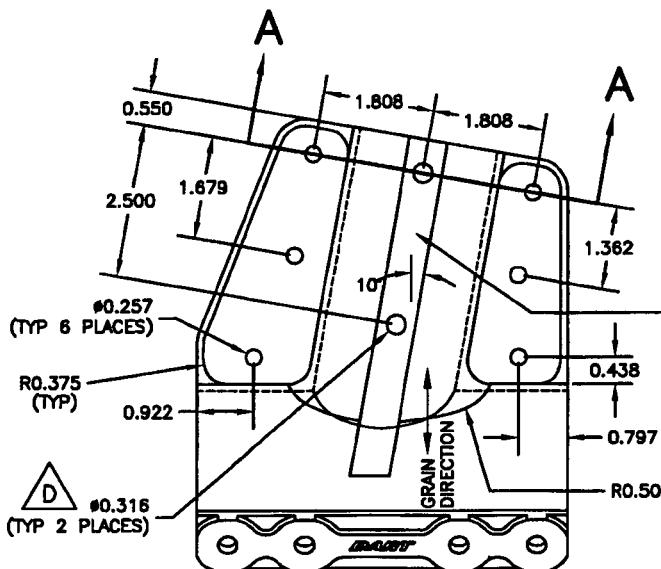


RELEASED

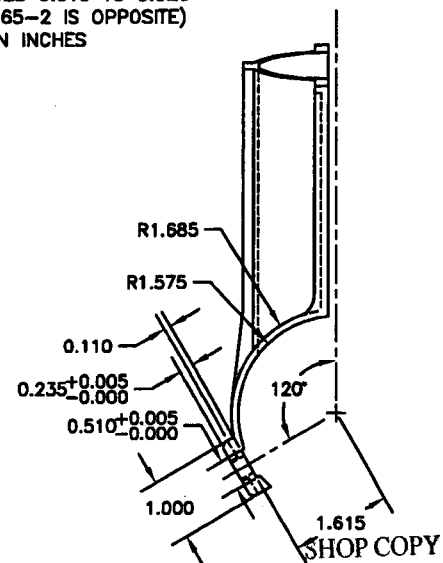
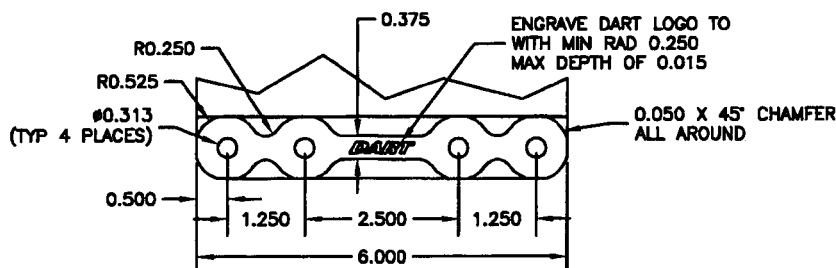
07.02.12 #

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010



D2665-1 SADDLE FWD OUTSIDE HIGH

WORK ORDER
NO. 415916

Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

